

Date: Wednesday, 4/26/2006 2:08:06 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER RING
 Job Number : 26862
 Estimate Number : 12176
 P.O. Number : N/A Part Number : D34765
 This Issue : 4/26/2006 S.O. No. : N/A Drawing Number : D3476 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 26619 Material : N/A
 Due Date : 4/28/2006 Qty: 5 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DAR
 Comment : Est Rev:A New Issue 06-02-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0907 sf(s)/Unit Total : 0.4536 sf(s)
 304/316 .063 Sheet
 Batch: M19059

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 Cut as per Dwg D3476
 Dwg Rev 034765 A
 Prog Rev 034765 A

MM 06 04 26 (5)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BE/MM 06 04 26 (5)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BE 06.04.26 (5)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

MM 06 04 26 (5)

2-Roll as per Dwg D3476

Boban 25 (5)

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Drawing Name: SPACER RING

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/26 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Bolan 26 (5)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/28 (5)

Job Completion

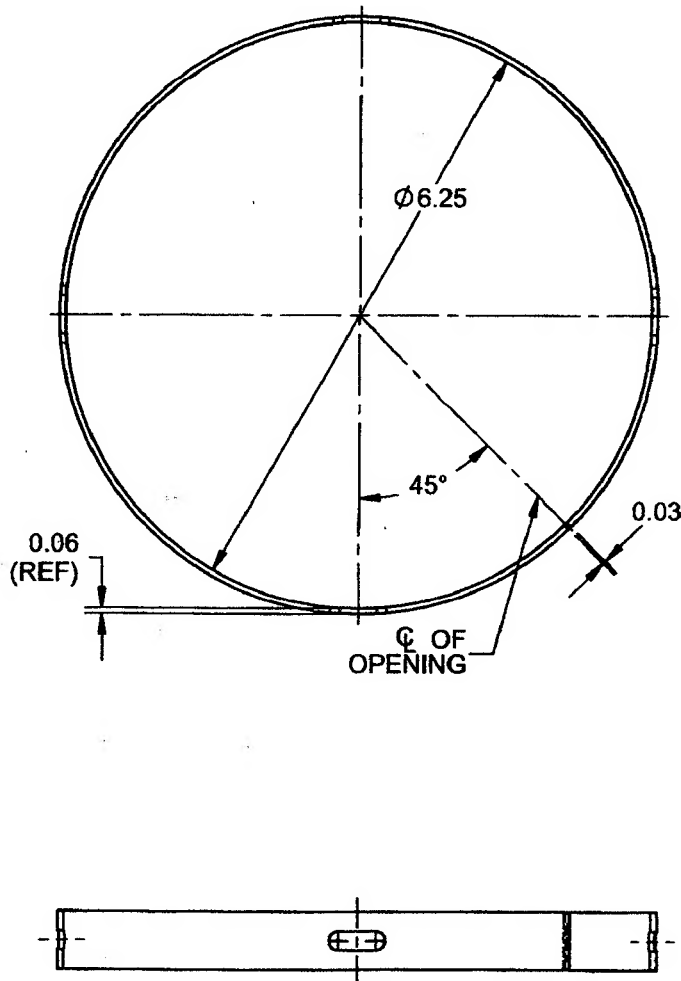


U 06.04.28

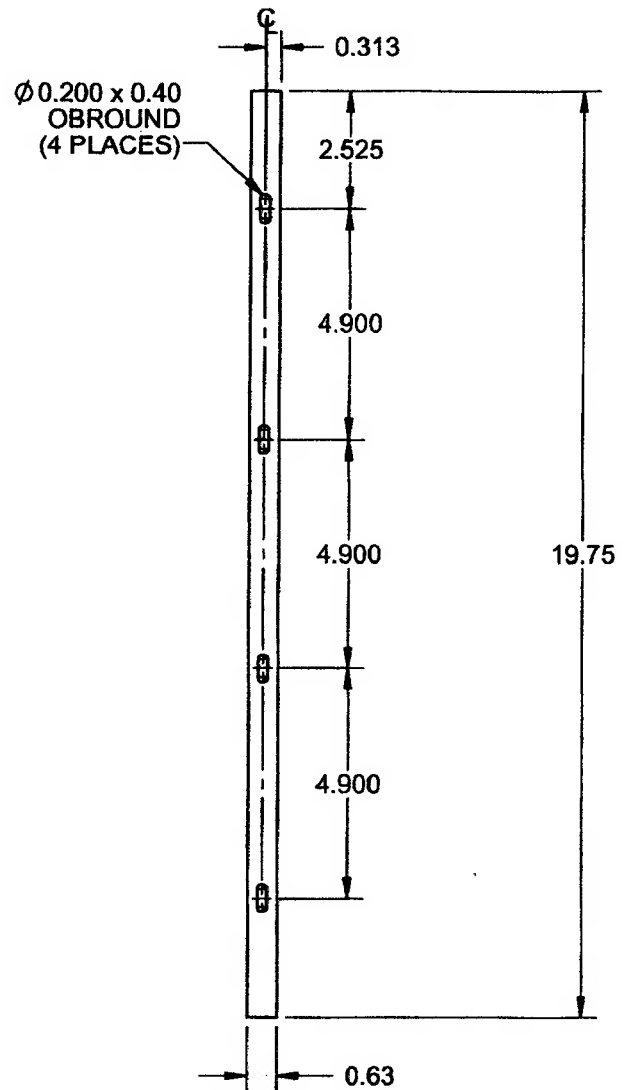


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:2

06.01.03



D3476-5 SPACER-RING



D3476-5F SPACER-RING
FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Work Order: 26862

Part Number: 3476-5

Rev:

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FIRST/ARTICLE INSPECTION CHECKLIST

First Article

Prototype

	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	$\pm .010$	0.313	✓		vern	
2.525	"	2.525	✓		vern	
4.900	"	4.900	✓		vern	
4.900	"	4.900	✓		vern	
4.900	"	4.900	✓		vern	
0.63	± 0.03	0.63	✓		vern	
19.75	"	19.75	✓		measuring tape	

Audited by:

Date:

Prototype Approval:

Date:

Revised by

KURF

Approved